

Date: Monday, 25/08/2008 7:54:12 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ROUND BILLET, ALUMINUM
Job Number	: 41609		
Estimate Number	: 12286		
P.O. Number	:	Part Number	: D6103003
This Issue	: 25/08/2008 S.O. No. :	Drawing Number	: D6103 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : PURCHASED PARTS	Drawing Revision	: B
Previous Run	: 38101	Material	:
Written By	: <u> </u>	Due Date	: 01/09/2008 Qty: 40 Um: Each
Checked & Approved By	: <u> </u>		
Comment	: Est Rev:A New Issue 06-02-09 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 7015

a) Description: Alluminum round billet

b) Ø3.500" x 12.500" long

c) Tolerance on all dimensions are +0.030"/-0.000"

d) Material: 7075-T7351 (QQ-A-225/9)

Material certification required

C208/08/25

(40)

2.0	D6103003P	round alum billet
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 40.0000 Each(s)
 alum billet

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

R 7/9/4 (44)

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

S 08/09/04 (44)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PU 8/9/5 22

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Drawing Name: ROUND BILLET, ALUMINUM

Job Number: 41609

Part Number: D6103003

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/10 *[Signature]*

Job Completion



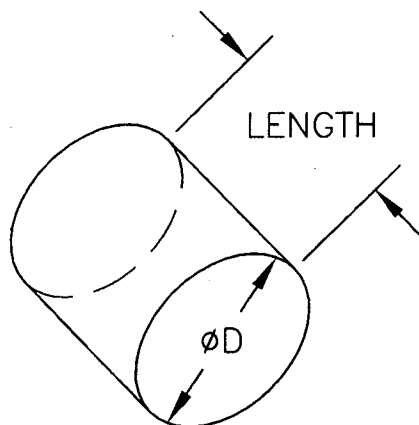
MF 08-09-05



DESIGN D/H	DRAWN BY D/H	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H/C	APPROVED H/C	DRAWING NO. D6103	Rev. B SHEET 1 OF 1
DATE 06.01.31		TITLE ROUND BILLET, ALUMINUM	SCALE NTS
A	01.04.10	NEW ISSUE	
B	06.01.31	ADD D6103-003	

SPECIFICATION CONTROL DRAWING

RELEASED
06.02.07



w/o 41609

PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, DIAMETER x LENGTH (+0.030/-0.000) AS SHOWN.

TOLERANCE ON ALL DIMENSIONS IS +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

Part No.	Alloy	D (Diameter)	Length
D6103-001	7075-T6/T651 (QQ-A-200/11 OR QQ-A-225/9)	Ø3.250	12.50
D6103-003	7075-T7351 (QQ-A-225/9)	Ø3.500	12.50

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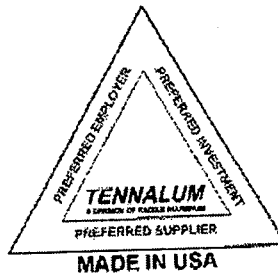
DIST.	NO. COM-ORD. NO.	NO. TRANS.	DE-FROM	SUP NOT BEFORE	SUP NOT AFTER	DEL NOT BEFORE	DEL NOT AFTER	CL	A. RAMM	DATE CHARGE-LOADED	NO. COM. ORD. NO.	POIDS TOTAL JOURNEE-TOT. DLY. WT.		
31	570607	647913	01	08/25/08	08/26/08	08/28/08	09/05/08	WF		EXPÉDIE 03 SEP. 2008				
NO. REQUISITION CLIENT-CUSTOMER REQUISITION NO.				NO. COM. CLIENT-CUST. ORD. NO.		COMPTÉ-ACCT.	VEND. SLS	TERR.	EXPÉDIE PAR-SHIP VIA		OU INT.-OR INT.			
				7015		91037	200	50	***** TRANSHIPMENT *****					
ACHETEUR-PURCHASING AGENT			TELEPHONE	H/C	TAXE	NO. COM ORD	REGION LIVRAISON-DEL ZONE		F.A.B.-F.O.B.		BILL	NO. FEVILLE/EMBALLAGE-B/L NUMBER		
JULIE DAWSON			613 632-3336	9	0	1	C/C		PREPAID					
VIVRE A-SHIP TO:				VENDU A-SOLD TO:				INFORMATION CRÉDIT-CREDIT INFORMATION			ROUTE			
				DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY ON K6A 1K7							01-NL-08/26 30-NL-09/03 31-NL-09/05			
INSTRUCTIONS/LIVRAISON-DELIVERY				INSTRUCTIONS LIVRAISON (CONT.)-DELIVERY (CONT'D.)				INSTRUCTIONS LIVRAISON (CONT.)-DELIVERY (CONT'D.)						
***** TRANSHIPMENT ***** PRIOR DIST/ORD: 01 647913				INQ-H81116										
DESCRIPTION - ITEM 1										QTE/UNITE COM.-ORDERED		POIDS COM.-WT. ORDERED		
3.5000 RD 7075-T7351 ALUM BAR CF 12.50" BLACK										44 PCS		534		
INSTRUCTIONS				INSTRUCTIONS (CONT'D.)				COULÉE INFO-HEAT INFO		QTE-QTY	BALLOTS-BUNDLES			
NBR OF DMTRS: MAIL W/MATL 1				TOL + 1/16" -0" CHICAGO: SHIP 4 FULL BARS CUT IN MONTREAL PRIOR DIST/ORD: 01 647913				20107712 ✓			1			
CASTLE (CHICAGO)				08/28/08				(44) X 12.50"		POIDS EST.-GROSS WT.		FORME-SHAPE	I.A.C.	
										550			8808	
										11.640FT				
								INSTRUCTIONS (CONT'D.)		AIRE/CHARGE-LOAD AREA		ENT.-WHSE.		
										N3				
DESCRIPTION - ITEM 2										QTE/UNITE COM.-ORDERED		POIDS COM.-WT. ORDERED		
INSTRUCTIONS				INSTRUCTIONS (CONT'D.)				COULÉE INFO-HEAT INFO		QTE-QTY	BALLOTS-BUNDLES			
PREPAID				1 Box							POIDS EST.-GROSS WT.		FORME-SHAPE	I.A.C.
								INSTRUCTIONS (CONT'D.)		AIRE/CHARGE-LOAD AREA		ENT.-WHSE.		
DESCRIPTION - ITEM 3										QTE/UNITE COM.-ORDERED		POIDS COM.-WT. ORDERED		
INSTRUCTIONS				INSTRUCTIONS (CONT'D.)				COULÉE INFO-HEAT INFO		QTE-QTY	BALLOTS-BUNDLES			
S / Métaux Castle 835 Selkirk Pointe-Claire, Que. H9R 3S2											POIDS EST.-GROSS WT.		FORME-SHAPE	I.A.C.
								INSTRUCTIONS (CONT'D.)		AIRE/CHARGE-LOAD AREA		ENT.-WHSE.		

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NE PAS TRAITER END DO NOT PROCESS

KAISER ALUMINUM

FABRICATED PRODUCTS

Tennalum
PO Box 669
Jackson, TN 38302
731-423-2811



CERTIFIED TEST REPORT
<http://KaiserEngProd.com>

CUSTOMER PO NUMBER: 01-11587		CUSTOMER PART NUMBER: 8808		PRODUCT DESCRIPTION: Cold Finished Round	
KAISER ORDER NUMBER: 644346	LINE ITEM: 1	SHIP DATE: 08/04/2008	ALLOY: 7075	TEMPER: T7351	
WEIGHT SHIPPED: 1972 lbs.	QUANTITY: 14 pcs.	B/L NUMBER: 28267	DIAM/DAF/THKNS: 3.500 in.	WIDTH: 0.000 in.	LENGTH: 144.0 in.
SHIP TO: A M Castle & Co 3400 No. Wolf Road Franklin Park, IL 60131 USA			SOLD TO: A M Castle & Co 3400 No. Wolf Road Franklin Park, IL 60131 USA		

Test Code: 1000 AC

Actual Physical Properties

Lot Number	LONG. UTS ksi	LONG. YTS ksi	LONG. ELONG. %	COND % IACS
20107712	72.0	61.3	13.0	39.3

Chemical Composition, WT. % (Aluminum Remainder)

	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	OTHERS EACH	OTHERS TOTAL	Lot
Actual	0.09	0.23	1.4	0.02	2.7	0.20	5.8	0.02			20107712
Max	0.40	0.50	2.0	0.30	2.9	0.28	6.1	0.20	0.05	0.15	
Min			1.2		2.1	0.18	5.1				

Specifications

Standard: ISO 9001, ASTM B211-03, AMS 4124D, AMS-QQ-A-225/9 Non-Standard: A97075-11-9

CASTLE METALS CORP.
DATE RCVD 8/16/08
IAC 8808
APPROVED BY as

CERTIFICATION

Kaiser Aluminum & Chemical Corporation ("Kaiser") hereby certifies that the metal shipped under this order has been inspected and tested and found in conformance with the applicable specifications forming a part of the description set forth in Kaiser's sales acknowledgement form. Any warranty is limited to that shown on Kaiser's general terms and conditions of sale. Test reports are on file, subject to examination.

John Rennekamp, Quality Manager

John Rennekamp

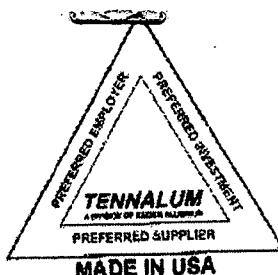
Plant Serial: 110681

Kaiser Order Number: 644346

Line Item: 1

**KAISER
ALUMINUM
FABRICATED PRODUCTS**

Tennalum
PO Box 669
Jackson, TN 38302
731-423-2811



CERTIFIED TEST REPORT
<http://KaiserEngProd.com>

Miscellaneous Notes

Made in USA

This material was melted and manufactured in the USA. Mercury is not a normal contaminant in aluminum alloys. Neither mercury nor any of its compounds were utilized by Kaiser Aluminum in the manufacture of this material. AS9100B:2004 This material meets the requirements of (cold finished) T73 temper and QQ-A-225/9E (CANCELLED). NAFTA - YES.

CERTIFICATION

Kaiser Aluminum & Chemical Corporation ("Kaiser") hereby certifies that the metal shipped under this order has been inspected and tested and found in conformance with the applicable specifications forming a part of the description set forth in Kaiser's sales acknowledgement form. Any warranty is limited to that shown on Kaiser's general terms and conditions of sale. Test reports are on file, subject to examination.

John Rennekamp, Quality Manager

Plant Serial: 110681

Kaiser Order Number: 644346

